

Blue

Dart Aerospace Ltd.

Date: Wednesday, 03/09/2008 10:25:52 AM  
 Ser: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206/OH-58 SADDLE, INBOARD, LEFT SIDE
<b>Job Number</b> :	41715		
<b>Estimate Number</b> :	10836		
<b>P.O. Number</b> :		<b>Part Number</b> :	D29391
<b>This Issue</b> :	03/09/2008	<b>Drawing Number</b> :	D2939 REV C - BLUE
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	C
<b>Previous Run</b> :	40283	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	26/09/2008
<b>Checked &amp; Approved By</b> :	<u>JULIE 08.9.03</u>	<b>Qty:</b>	3
<b>Comment</b> :	Est: B00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101001	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Issue material from stock: 7075-T7351 QQ-A-250/12  
 Cut Size 2.0 x 6.25 X 6.00  
 Grain Along Long 6.00 Length  
 Batch No: 34872

28 08/09/11 (3)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet  
 5-Deburr

28 08/09/11 (3)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

28 08/09/11 (3)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

28 08/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 10:25:52 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 41715

Part Number: D29391

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/09/12 (3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

gl

08 - 09 - 15 (X3)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B106729

-SPRAY PAINT DELFLEET BLUE

B105918

-CLEAR DELFLEET

B109333

ml 08 09 23

(3)

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

08-09-25

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 445

8/9/25

(3x)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/26 ff

Job Completion



U 0809-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

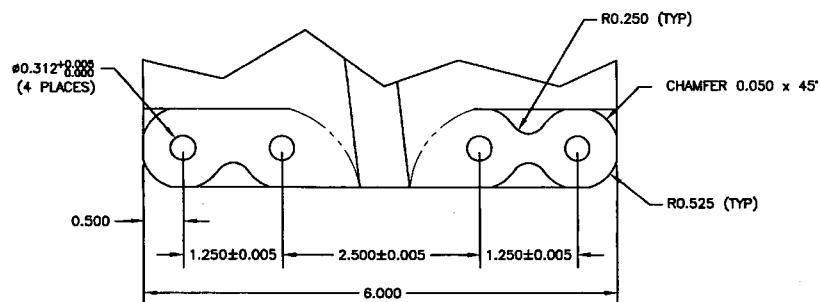
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41715
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b> D2939-1
<b>Inspection Dwg:</b> D2939 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.130	.130	.130			
B	0.100	0.140		.130	.130	.130			
C	0.100	0.140		.115	.115	.115			
D	0.210	0.230		.225	.227	.225			
E	1.245	1.255		1.246	1.250	1.250			
F	1.245	1.255		1.249	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.510	.510	.510			
I	1.572	1.582		1.578	1.578	1.578			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.258	.258	.258			
L	0.312	0.317		.314	.314	.314			
M	0.235	0.240		.238	.237	.238			
N	0.100	0.140		.111	.112	.112			
O	0.540	0.560		.550	.550	.552			
P	0.490	0.510		.504	.504	.502			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.720	2.760		2.742	2.742	2.742			
S	0.240	0.270		.258	.258	.258			
T	0.100	0.180		.140	.140	.140			
U	1.625	1.635		1.628	1.628	1.628			
V	1.362	1.372		1.367	1.367	1.367			
W	0.316	0.321		.320	.320	.320			
X	1.250	1.270		1.260	1.260	1.260			
Y	1.565	1.585	DT8695 A/B	1.580	1.580	1.580			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: S.F.	Audited by: J.F.
Date: 08/09/12	Date: 08/09/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

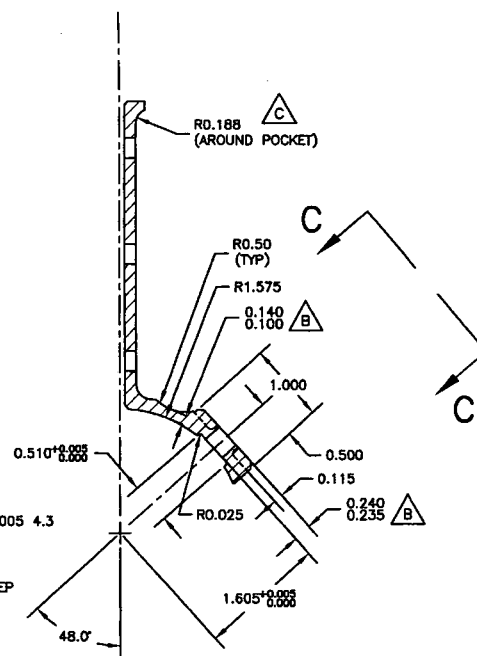


VIEW C-C

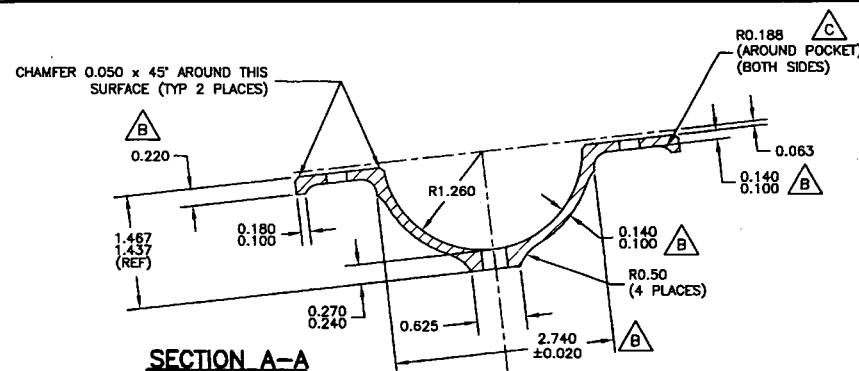
**D2939-1 LH SADDLE (SHOWN)**  
**D2939-2 RH SADDLE (OPPOSITE)**

**NOTES:**

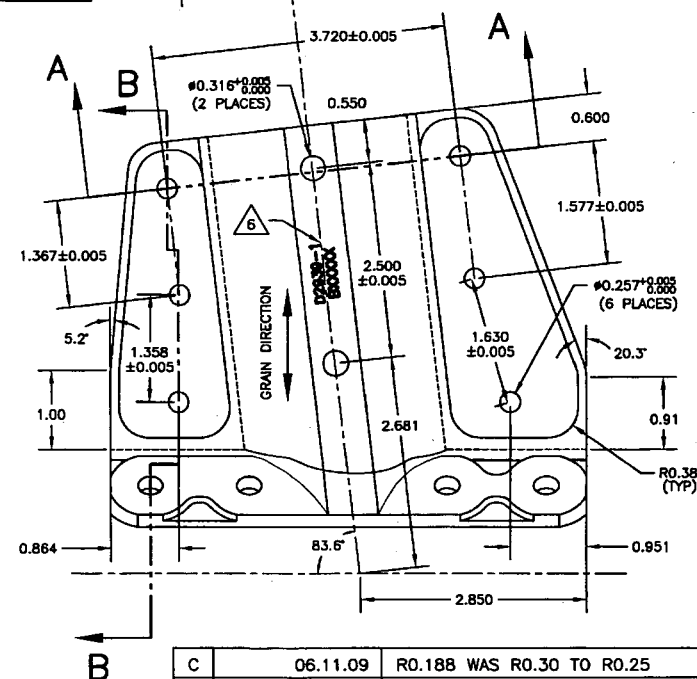
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC.
CHECKED	PH	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE

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DART DART AEROSPACE USA, INC.  
 BELLEVUE, WA

DRAWING NO. D2939

TITLE SADDLE INSIDE

REV. C SHEET 1 OF 1

SCALE 2:3

07.02.12

NO. 41775  
 WORK ORDER  
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